| Item ID: | D3255-042 | | Accept | *N900040100* | Setup | Start | *NS1* |

Revision ID:

| Item Name: | Access Panel Assembly | | | | | Stop | *NS2* |

| Start Date: | 5/27/13 | Start Qty: 2.00 | *2* 3 | Cust Item ID: |
| Required Date: 5/31/13 | Req'd Qty: 2.00 | *2* | Customer: |

Reference:

| Approvals: | Process Plan: __MLJ__ | Date: 13-05-29 | Tooling: _____ | Date: _____ | Run | Start | *NR1* |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | *NR2* |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								13-09-17
100 *100* Large Fab Large Fab	Large Fab Memo 1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD Batch: M125054 2-Grind Welds Flush	0.00 0.00				3			MC
110 *110* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	DAS 27 9-89 13 9 18			3			
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 27 9-89 13 9 18			3			

NCR: Yes / No   # WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: _____ Part No. _____ NCR No. _____	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other
- _____
- _____
- _____

Item ID:	D3255-042		Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						Stop	*NS2*
Item Name:	Access Panel Assembly						
Start Date:	5/27/13	Start Qty: 2.00	*2*	Cust Item ID:			
Required Date: 5/31/13	Req'd Qty: 2.00		*2*	Customer:			
Reference:							

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ | Run | Start | *NR1* |

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ | | Stop | *NR2* |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME:	0.00 0.00 OVEN TEMPERATURE:				3x Ø m√ 13/09/18			
	FINISH TIME:	320°F 11-30							

W121279

| 140
140
QC
Quality Control | QC3- Inspect Part Finish

Memo | 0.00

0.00 | | | | 3x d M 12/09/18 | | | |

| 150
150
Small Fab
Small Fab | Small Fab

Memo | 0.00

0.00 | | DAS
30
9-89 | | 3 | | | 13/11/22 |
| | 1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg
D3255A/R   736   DOW CORNING ADHESIVE
Batch: M12234C | | | | | | | | |

11-00

NCR: Yes / No   # WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____ Part No. _____ NCR No. _____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear		**General**				
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

			Accept	*N9000040100*	Setup	Start	*NS1*
Item ID:	D3255-042					Stop	*NS2*

Revision ID:

Item Name: Access Panel Assembly

Start Date:	5/27/13	**Start Qty:** 2.00	*2*	**Cust Item ID:**
Required Date: 5/31/13		**Req'd Qty:** 2.00	*2*	**Customer:**

Reference:

Run   Start   *NR1*

Approvals:	**Process Plan:** _____	**Date:** _____	**Tooling:** _____	**Date:** _____
	QC: _____	**Date:** _____	**SPC (Y/N):** _____	**Date:** _____

Stop   *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				3 2			
	Memo	0.00 13/11/22							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location:_____	0.00				2 13/4/22			DAS 32 9-89
	Memo 5/176	0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00				13-11-22			
	Memo	0.00							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			
Part No. _____			
NCR No. _____			

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Picklist Print

May-28-13 8:50:25 AM

Work Order ID: 102401

Parent Item: D3255-042 **Start Date:** 5/27/13 **Required Date:** 5/31/13

Parent Item Name: Access Panel Assembly **Start Qty:** 2.00 **Required Qty:** 2.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2 Panel		Manufactured	No	*102138*		100	Each	0.0000	1 *3*	2			
D3255-5 Gasket		Manufactured	No			100	Each	8.0000	1	2		13-09-11	

Location	Loc Qty	Loc Code
GA	8	M102788 ③
72118	1	
75083	1	DAS 30
98928	6	9-89

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-3 Cap		Manufactured	No			150	Each	8.0000	1	2		13-09-11	

Location	Loc Qty	Loc Code
WA001 *99285*	6	*13*
75969	2	
98272	4	
WA002	2	
83201	2	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| Work Order: _____ |
| Part No. _____ |
| NCR No. _____ |

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
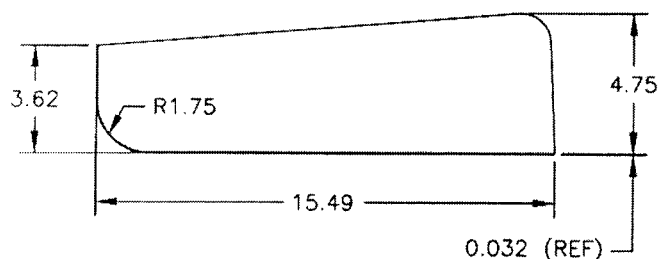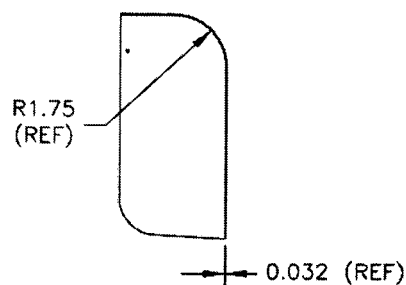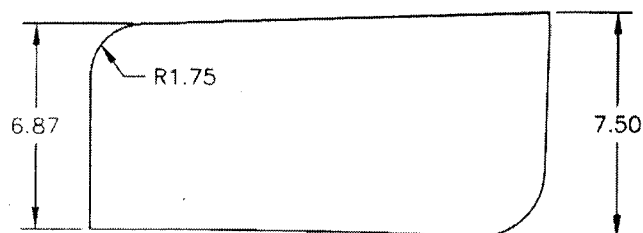☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

RELEASED

WELD D3255-3

D3255-5 GASKET

D3255-1 PANEL (SHOWN)
D3255-2 PANEL (OPPOSITE)

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)

R1.75
6.87
7.50

R1.75
(REF)

0.032 (REF)

3.62
R1.75
4.75
15.49
0.032 (REF)

D3255-1 BEND DETAIL
D3255-2 OPPOSITE

102401 MLS
13-05-29

D3255-041/-042 NOTES:
1) WELD PER DART QSI 004
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE
   WITH MANUFACTURE'S INSTRUCTIONS
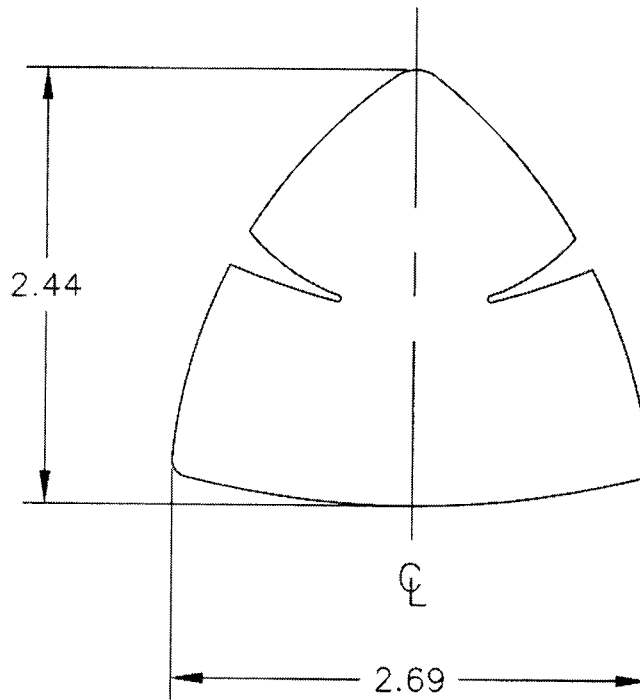4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA

CHECKED	APPROVED	DRAWING NO.	REV. B
		D3255	SHEET 2 OF 4

DATE	TITLE	SCALE
04.12.06	TITLE	1:1

D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:
1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
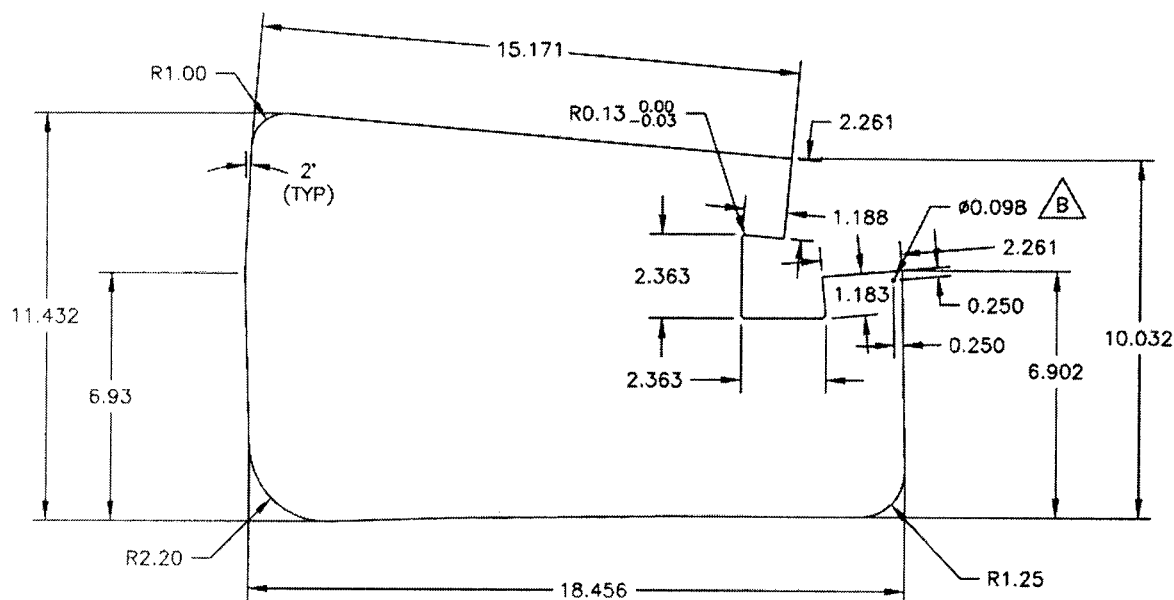5) BREAK ALL SHARP EDGES 0.005 TO 0.010
6) MAKE PER DRAWING "D3255-B2.DWG"

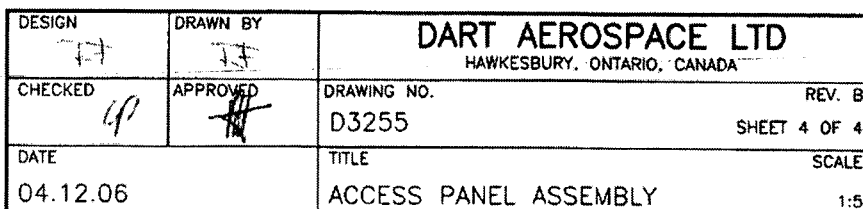| DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3255	SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5

RELEASED
05 01 18

D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:
1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
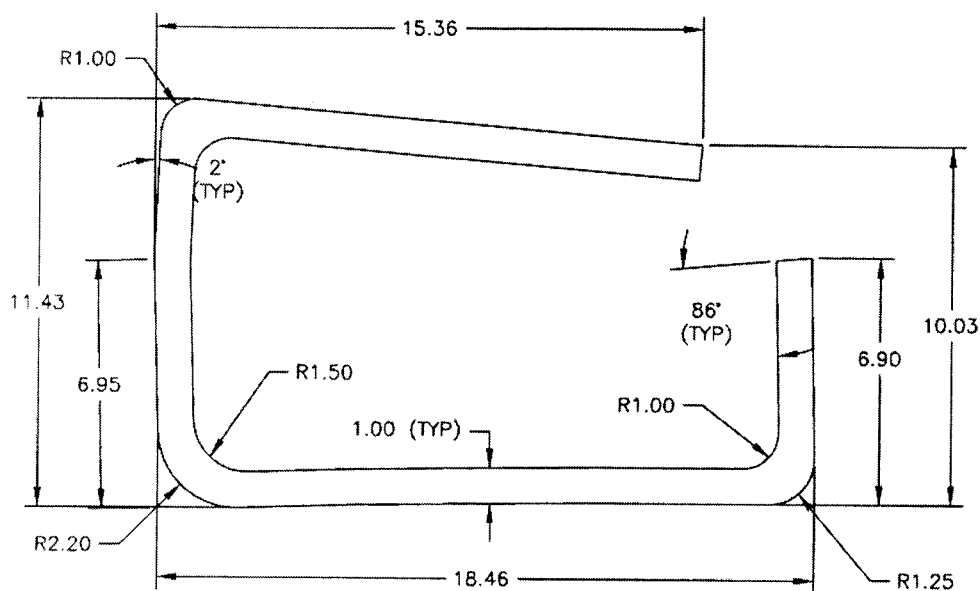3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5

RELEASED
05 01.18

D3255—5 GASKET

D3255—5 NOTES:
1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
     P/N SIL/F 36x36x1/16
   POSSIBLE SUPPLER: AVIALL
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES